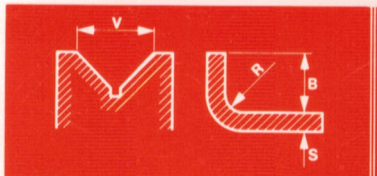
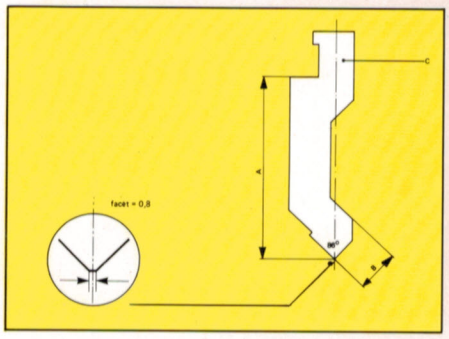
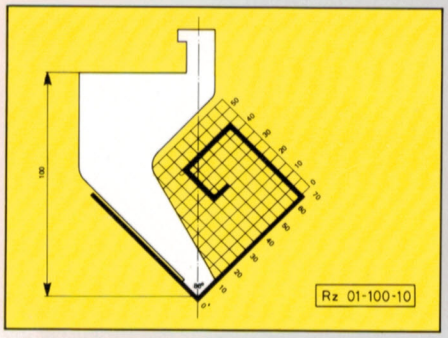
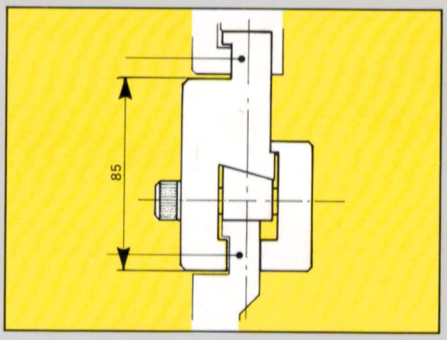
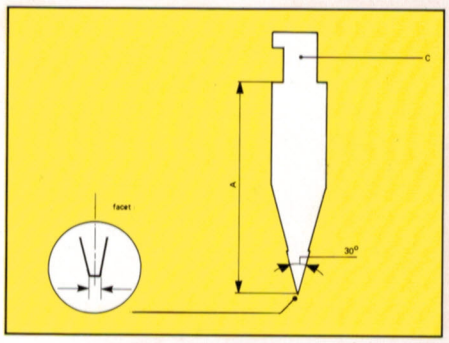
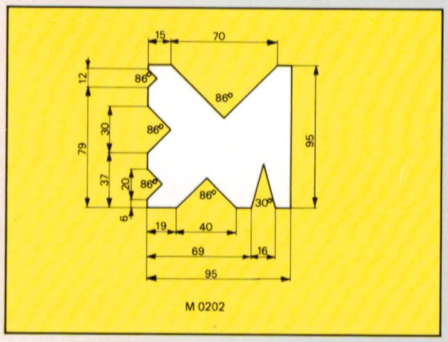
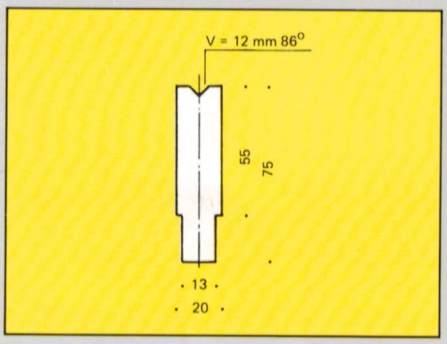
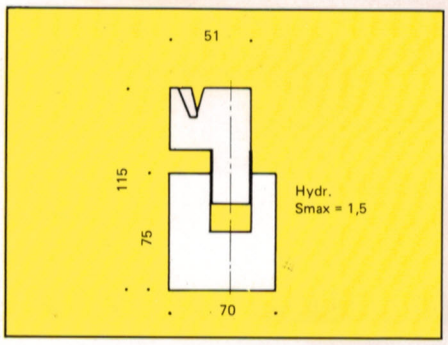
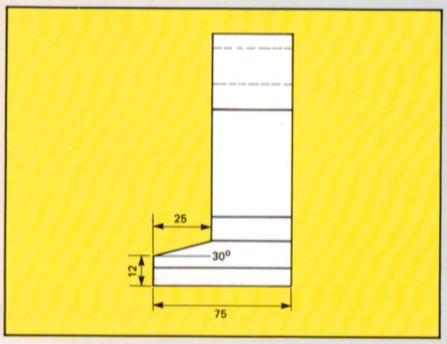
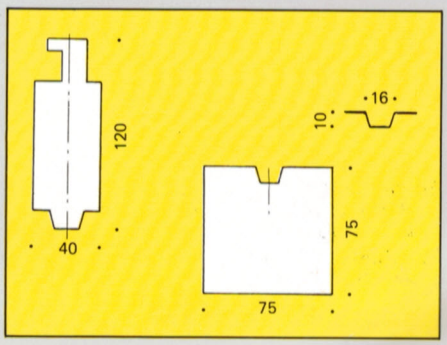


Wahl V = 8 x S

Preßdruck in Tonnen je Meter

Blech-dicke S	Innenradius R																									
		1.5	1.6	2	2.5	3.2	4	5	6	7	7.5	8	9	10	10.5	11	12	13	13	14	15	16	17	19	21	23	26
	Kleinster Abkantschenkel B																										
		6	7	9	11	13	16	20	22	26	28	32	34	38	41	44	47	50	53	57	60	63	69	76	82	92	100
	Offnung Matrize V																										
mm	6	8	10	13	16	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	110	120	130	145	150
0.5	3																										
0.75	7	5																									
1	12	9	7	6																							
1.2		14	10	8	6																						
1.5		24	19	13	10	7	5																				
2				21	17	14	11	9																			
3				64	47	30	24	20	17	15																	
4							43	36	31	27	24	22															
5									48	42	37	34	31	28	26												
6										60	54	48	44	40	37	35	32										
7											75	66	60	55	50	47	44	41	39	37							
8												85	78	71	66	61	57	53	50	48	45	43					
9														90	83	77	72	68	64	60	57	54	49	45			
10															100	95	89	83	79	74	70	67	61	56	52		
11																115	108	100	95	90	85	81	74	68	62	56	
12																	128	120	113	107	101	96	87	80	74	66	60
13																			132	125	118	112	102	94	87	78	70
14																				145	138	130	120	109	100	90	82
15																						150	136	125	115	104	94
16																							155	142	132	118	106
19																								180	166	150	135
22																									205	185	170
25																										225	205

Unter Benützung der obenstehenden Tabelle kann der jeweilige Preßdruck, welcher erforderlich ist in ein Blech mit Zugfestigkeit von 45 kg/mm² zu kanten, je Meter Läge in Tonnen berechnet werden.

Hierbei sind Länge und Blechstärke, der kleinste Radius (R) sowie der kleinste Abkantschenkel (B) von großer Wichtigkeit.